

Date: Wednesday, 4/19/2006 8:14:41 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DOUBLER
Job Number : 26723	
Estimate Number : 11471	
P.O. Number : N/A	Part Number : D3140101
This Issue : 4/19/2006 S.O. No. : N/A	Drawing Number : D3140 REV D1
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : D1
Previous Run : N/A	Material : N/A
Written By : <u>See comment below</u>	Due Date : 4/26/2006 Qty: 4 Um: Each
Checked & Approved By : <u>06.04.19</u>	
Comment : Est. A 02.04.30 New Issue NG Est. B 06.04.18 New dwg rev. ecn781 EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S032	2024-T3 .032 sheet
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Comment: Qty.: 0.0466 sf(s)/Unit Total : 0.1865 sf(s)
 2024-T3 .032 sheet
 Matl: 2024-T3 (QQ-A-250/4) .032" thick
 (M2024T3S.032) 2.20" x 2.80" ref
 Note: Part not square.

Batch M12758

2.0	SHEAR	SHEAR
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Comment: SHEAR
 Cut as per dwg D3140
 Deburr. No sharp edges

Hand mademl 06/04/19

3.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------

**Comment:** INSPECT WORK TO CURRENT STEP06.04.20 (4)

4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1
 Chemical Conversion Coat as per QSI 005 4.1

DL 06/04/20

5.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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**Comment:** INSPECT POWDER COAT/CHEMICAL CONVERSIONC 206/04/20 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: 7 Date: 06/04/21
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 4/19/2006 8:14:41 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 26723

Part Number: D3140101

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

C206/04/20 (4)

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SI 00/04/21 (4)

Job Completion



U 06-04-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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CHECKED 	APPROVED 	DRAWING NO. D3140	REV. D SHEET 1 OF 7
DATE 05.11.23		TITLE DOOR	SCALE NTS
A	02.04.18	NEW ISSUE	
B	03.01.23	REMOVE -65/-81/-83; ADD -301/-303	
C	04.11.08	CHANGE DELASTEK SPEC. TEC-77; ADD PART MARKING; ADD NOTES 11, 12, 13; CHANGE ANGLE -95/-97/-98 TO 106°	
D	05.11.23	ADD -103/-104/-105/-106; REMOVE -67	
DI	06.03.31	1.75 WAS 1.85 ; 4.75 WAS 4.13	

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05.11.23

QTY -05	QTY -06	QTY -07	QTY -08	QTY -09	QTY -10	PART NUMBER	DESCRIPTION
X						D3140-05	DOOR
	X					D3140-06	DOOR
		X				D3140-07	DOOR
			X			D3140-08	DOOR
		1		X		D3140-09	DOUBLER ASSEMBLY
			1		X	D3140-10	DOUBLER ASSEMBLY
3	3					D3140-57	PAD
1	1					D3140-59	PAD
2	2					D3140-61	PAD
2	2					D3140-63	PAD
		1	1			D3140-69	PAD
		1	1			D3140-71	PAD
		1	1			D3140-73	PAD
		1	1			D3140-75	PAD
		1	1			D3140-77	PAD
		1	1			D3140-79	PAD
				1	1	D3140-85	ANGLE
1	1					D3140-87	DOUBLER
				1	1	D3140-89	DOUBLER
		1				D3140-91	DOUBLER
			1			D3140-92	DOUBLER
3	3					D3140-95	DOUBLER
1						D3140-97	DOUBLER
	1					D3140-98	DOUBLER
		1	1			D3140-99	DOUBLER
		2	2			D3140-101	DOUBLER
		1				D3140-103	DOUBLER
			1			D3140-104	DOUBLER
		1				D3140-105	DOUBLER
			1			D3140-106	DOUBLER
1	1					D3140-241	DOUBLER
1		1				D3140-301	DOUBLER
	1		1			D3140-303	DOUBLER
				5	5	MS20426AD3-4	RIVET

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DATE 05.11.23		TITLE DOOR	SCALE NTS

1

COMPOSITE LAYUP & BONDING I.A.W. DELASTEK PROCESS SPEC. TEC-77
MATERIAL STORAGE & HANDLING TO BE I.A.W. DART QSI 006
MAIN LAYUP USES FIBERCOTE E-761/7781 EPOXY FIBERGLASS.
FILL WITH EPOCAST 87269 OR MAGNOBOND 77 A & B AND MA560 FOAM/ NB-51/30 FOAM

2

FINISH: DUPONT HIGHBUILD GREY PRIMER 1144-S

3

MAKE PARTS IN ACCORDANCE WITH THE FOLLOWING TOOLS/MOLDS:

PART	TOOL
D3140-05	B30-23000-01T
D3140-06	B30-23000-02T
D3140-07	B30-23000-03T
D3140-08	B30-23000-04T
D3140-57	B30-23000-57T
D3140-61	B30-23000-61T
D3140-63	B30-23000-63T
D3140-69	B30-23000-69T
D3140-71	B30-23000-71T
D3140-73	B30-23000-73T
D3140-75	B30-23000-75T
D3140-77	B30-23000-77T
D3140-79	B30-23000-79T
D3140-89	D3140-89T1
D3140-301	D3140-301T1
D3140-303	D3140-303T1

RELEASED
05.12.01

4

MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (M2024T3S.032)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

5

MATERIAL: 2024-T3 (QQ-A-250/4) 0.020 THICK (M2024T3S.020)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

6

MATERIAL: 5052-H32/H34 (QQ-A-250/8) 0.040 THICK (M5052H32S.040)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

7

MATERIAL: POLIMEX TR75 1" THICK 4.5 LB KLEGECELL

8

ALL DIMENSIONS IN INCHES

9

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

10

MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (M6061-T6S.063)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

11

DOUBLER TO SIT ON TOP OF FOAM AT THIS LOCATION

12

DOUBLER TO BE RECESSED FLUSH INTO FOAM AT THIS LOCATION

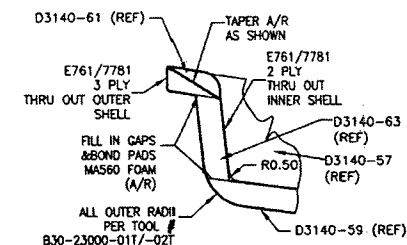
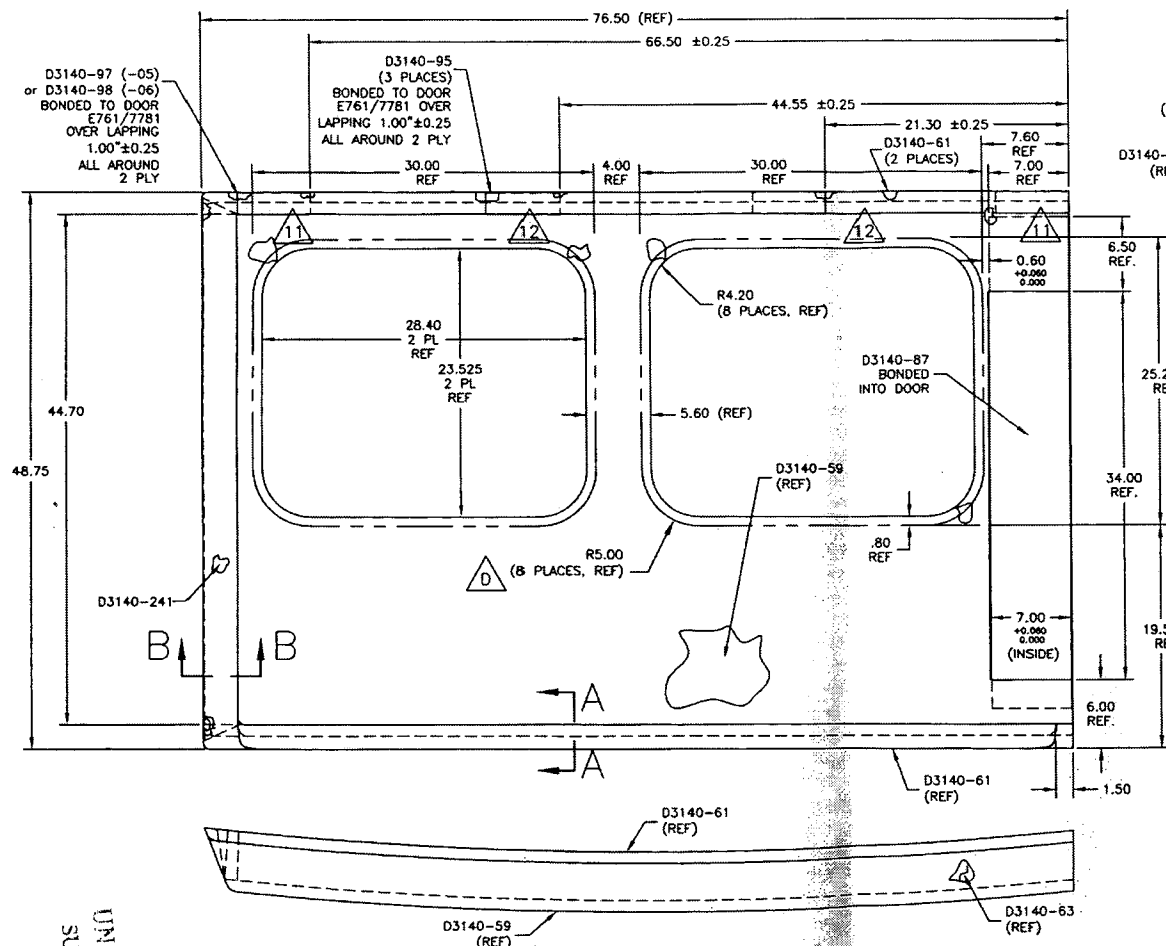
13

RUBBER STAMP WITH DART P/N D3140-05/-06/-07/-08 USING MIL-STD-130

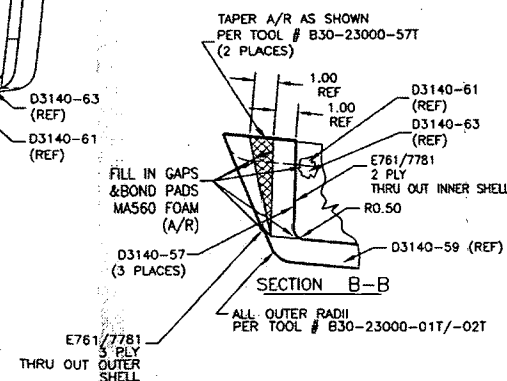
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D3140-05 DOOR (SHOWN, REPLACES PREMIER P/N B30-23000-05)
D3140-06 DOOR (OPPOSITE, REPLACES PREMIER P/N B30-23000-06)
(WINDOWS & CUTOUTS TO BE LOCATED PER B30-23000-01T/-02T TOOL)

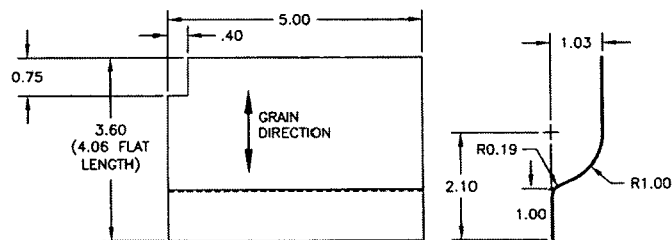
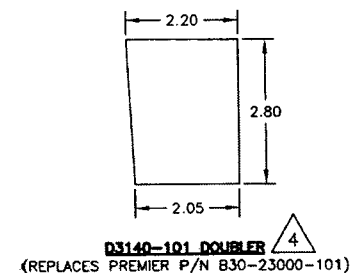
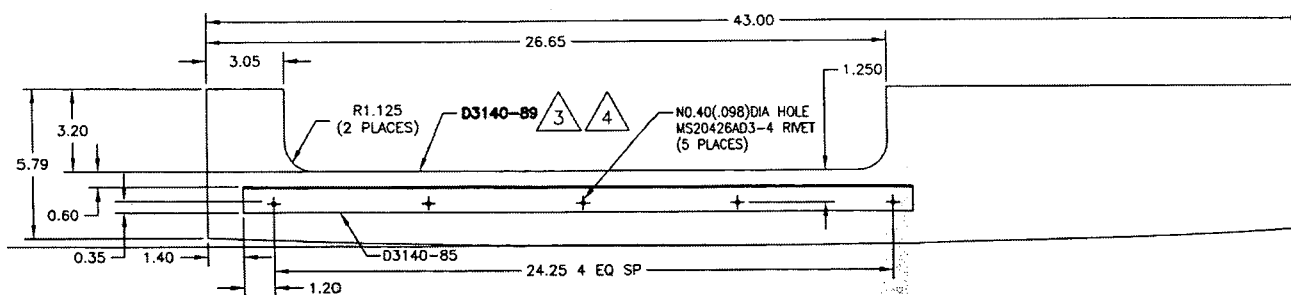
1 2 3

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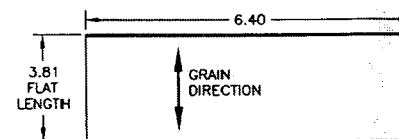
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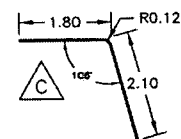


D3140-91F FLAT PATTERN
(USE TO MAKE D3140-91/-92 DOUBLERS)

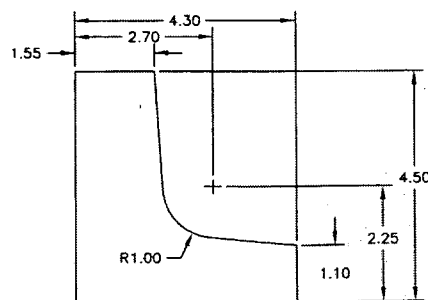
D3140-91 DOUBLER (SHOWN, REPLACES PREMIER P/N B30-23000-91)
D3140-92 DOUBLER (OPPOSITE, REPLACES PREMIER P/N B30-23000-92)



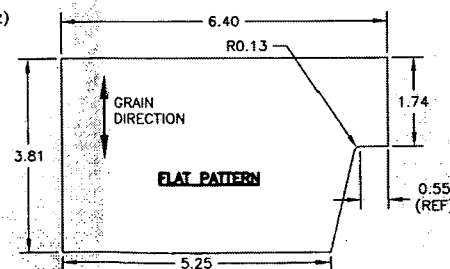
D3140-95 DOUBLER (REPLACES PREMIER P/N B30-23000-95)



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D3140-99 DOUBLER (REPLACES PREMIER P/N B30-23000-99)




D3140-97F FLAT PATTERN (USE TO MAKE D3140-97/-98 DOUBLERS)

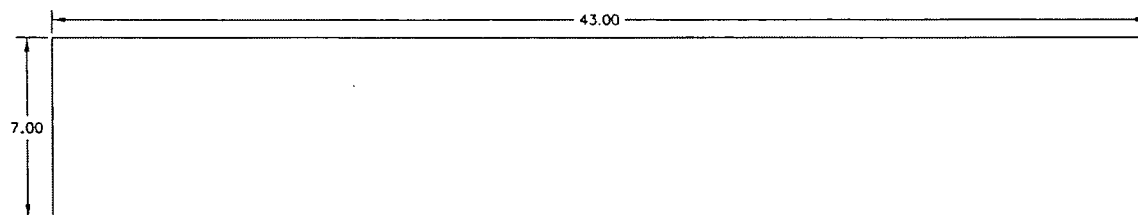


BEND DETAIL

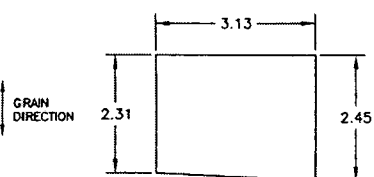
D3140-97 DOUBLER (SHOWN, REPLACES PREMIER P/N B30-23000-97)
D3140-98 DOUBLER (OPPOSITE, REPLACES PREMIER P/N B30-23000-98)

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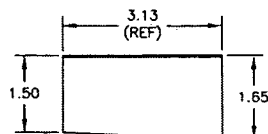
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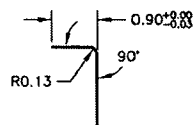
D3140-87 DOUBLER $\triangle 4$
(REPLACES PREMIER P/N B30-23000-87)



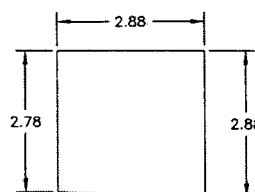
D3140-105F FLAT PATTERN
(USED TO MAKE D3140-105/-106 BRACKETS)



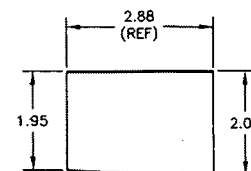
D3140-105 DOUBLER
D3140-106 OPPOSITE



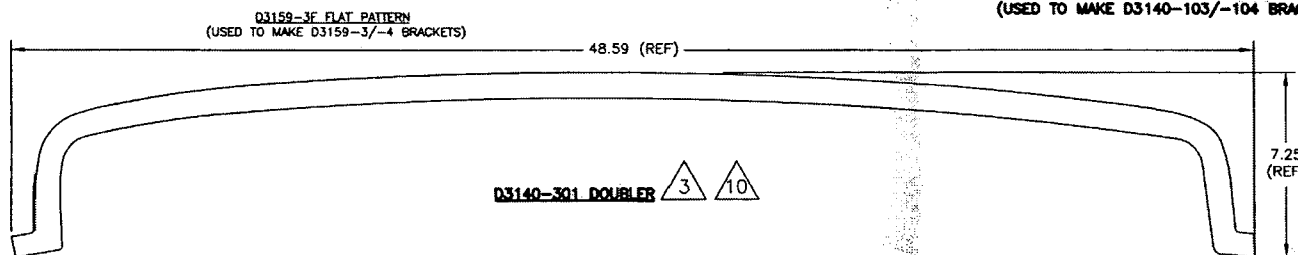
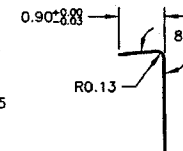
GRAIN DIRECTION



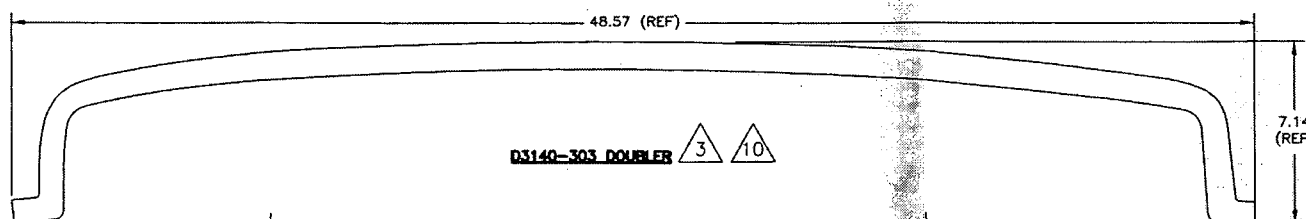
D3140-103F FLAT PATTERN
(USED TO MAKE D3140-103/-104 BRACKETS)



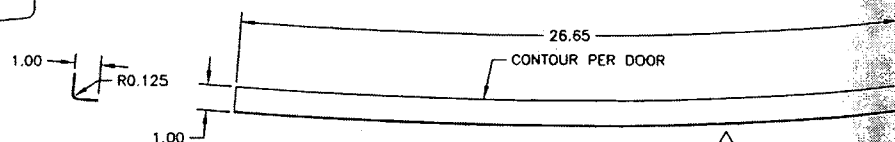
D3140-103 DOUBLER
D3140-104 OPPOSITE



D3140-301 DOUBLER $\triangle 3$ $\triangle 10$



D3140-303 DOUBLER $\triangle 3$ $\triangle 10$



D3140-85 ANGLE $\triangle 6$
FLAT PATTERN: 26.65" x 1.90"
(REPLACES PREMIER P/N B30-23000-85)

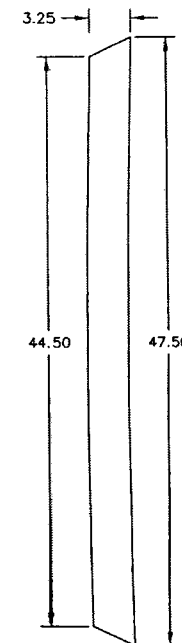
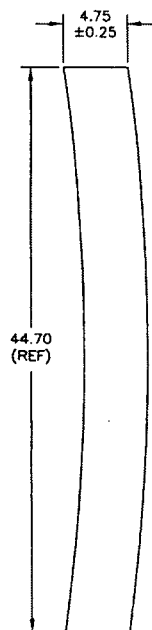
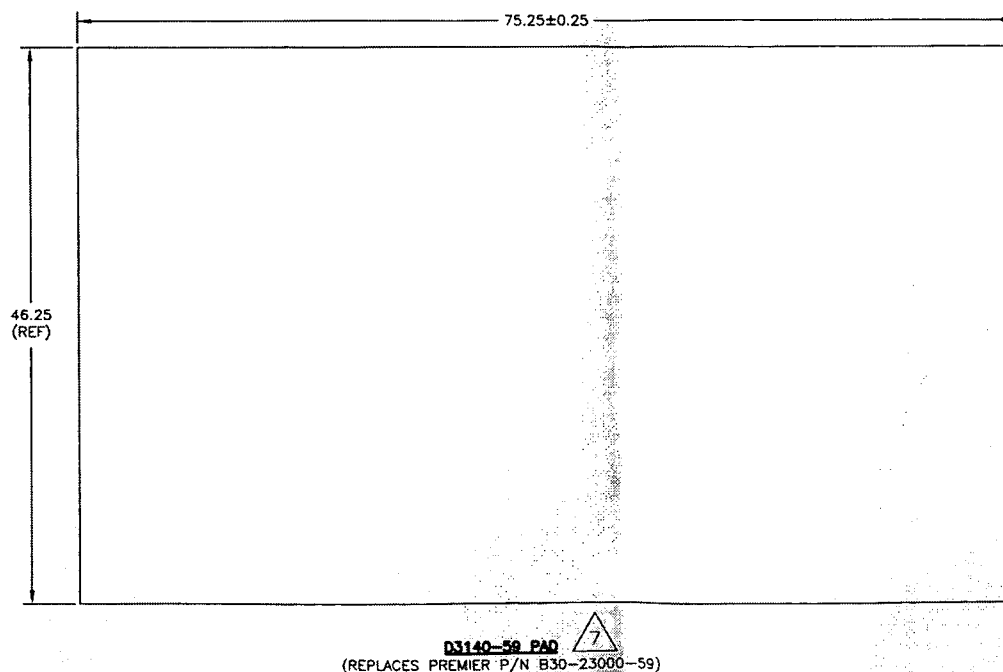
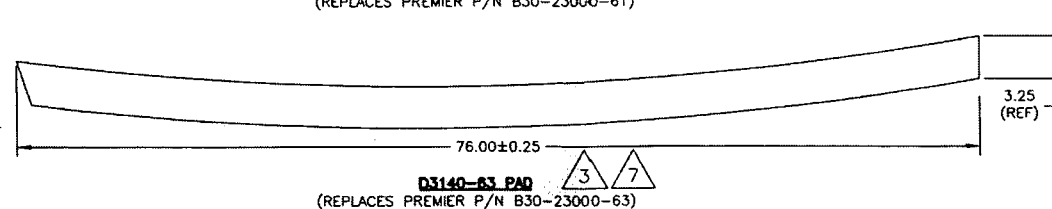
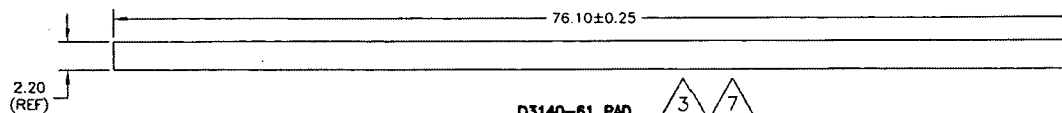
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